

Date: Tuesday, 12/20/2005 3:30:15 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b> : 25314	
<b>Estimate Number</b> : 10265	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D350636012
<b>This Issue</b> : 12/20/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2750 REV C1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 12/20/2005 <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : C1
<b>Previous Run</b> : 25313	<b>Material</b> : N/A
<b>Written By</b> : <u>SEE COMMENT BELOW</u>	<b>Due Date</b> : 1/20/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : _____	
<b>Comment</b> : Est Rev:1 02.09.25 Rearranged procedure steps KJ	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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KJ 06-01-43 ①

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 001

See attached 1A

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B25384

Pm' 06-03-09 ①

3.0	D2744	Fwd Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2744

Cap

B24672 BE 06-05-25 ①

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

1-Cut D2600-3-Bent aft end to length as per Dwg D2750 Mark cut line using Jig DT 8150. Deburr end Pm' 06-03-09 ①

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1) and mark fwd end for cutting using Drill Jig DT 8150. Second side of Detail B to be Drilled using DT 8330 Pm' 06-03-09 ①

3-Open up holes for Detail B, D and 2 aft 0.500" AE holes to finished size as per Dwg D2750 and DEO 9133 Do not open any 0.625" AE holes to finished size Pm' 06-05-24 ①

4-Drill pilot holes as per Dwg D2750 (Sheet 3, D2750-2), mark Fwd end for cutting using Drill Jig Pm' 06-05-24 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Job Number: 25314

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Job Number:



Seq. #:

Machine Or Operation:

Description :

DT8150, then drill both sides.

5-Open holes as per detail "P" To 500", then Drill pilot holes to detail "B" using DT8329

\*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open holes to .500" as per detail "B&C".

7-Open holes to .375" as per detail "D"

8-Cut fwd end of tube as per Dwg D2750

9-Drill pilot holes for wearplates using DT 8108 Open holes to 0.297" and Open holes per Dwg D2750 detail A

10-Open holes to .590" as per detail "D".

11-Deburr

12-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *MI9101 BE 06-05-25*

13-Grind welds flush as per Dwg D2750 *BE 06-05-26*

*PM 06-05-26*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *BE 06-05-29*

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*PD 06-05-29*

7.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2739 Web

*B26385 PM 06-05-29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Tuesday, 12/20/2005 3:30:16 PM  
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## Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

8.0 D2743 Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 D2743 Crossbolt spacer

B-25838 BE 05-06-30 (1)

9.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open 0.625" AE holes and countersink for welding crossbolt spacers as per Dwg D2750. Do not use cutting oil *pmc 06-05-29 (1)*

2-Deburr and blow out all chips from inside of tube *pmc 06-05-29 (1)*

3-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

Sikaflex expire date: *06-11-21*

*M100901 pmc 06-05-29 (1)*

4-Weld crossbolt spacers D2743 as per Dwg D2750 and QSI 004

A/R Aluminum Rod

*M19101 BE 05-06-30 (1)*

5-Grind welds flush as per Dwg D2750 *pmc 06-05-30 (1)*

6-Spot face ground handling holes AE0.750" (8 places) *pmc 06-05-30 (1)*

7-Deburr holes *pmc 06-05-30 (1)*

10.0 QC5/9 WELD INSPECTION



*PD 06-06-05*

Comment: Inspect weld and work to Step 20

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*a.m 06-06-09 (1)*

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*DL 06-06-09 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	D27422	Blade Fitting, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2742-2	Blade Fitting, LH	B24640

14.0	AN835A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN8-35A	Bolt	M18576

15.0	AN960JD816	1/2" washer, Alum
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN960JD816	Washer	M6956

16.0	MS21083N8	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21083N8	Nut	M19099

17.0	D26483	Wearpad
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Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
5	D2648-3	Wearpad	B25904

18.0	D265613	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-13	Wearplate	B25914

06/06/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	D265635	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2656-35	Wearplate	B24148

20.0	D2746	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2746	Wearplate	B25841

21.0	ALS41032225	Insert
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Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
46	ALS4-1032-225 ✓	Insert	M400489
	(or AKS4-1032-225)		
	(or ALS7-1032-225)		
	(or AKS7-1032-225)		

22.0	AN960JD10L	Washer
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Comment: Qty.: 42.0000 Each(s)/Unit Total : 42.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
42	AN960JD10L	Washer	M18235

23.0	AN35A	Bolt
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
38	AN3-5A	Bolt	M15205

DL 06/06/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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24.0	AN36A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

25.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D2745	Bushing	B24879 X 6 B27187 X 2

26.0	AN644A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN6-44A	Bolt	M19471

27.0	MS21042L6	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L6	Nut (or -6)	M17614

28.0	AN332A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-32A	Bolt	M19513

DU 06/06/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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29.0	A3235020935	Washer - Countersunk
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	A3235-020-935	Plug	M183C9

30.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	MS21042L3	Nut	M100393

31.0	AN36A	Bolt
------	-------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-6A	Bolt	M100274

32.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960JD10	Washer	M10066 X2, M100151 X2 DL 06/06/13

33.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

1-Assemble as per Dwg D2750 Page 4 Detail P. Install D2742-2 and seal with Sikaflex adhesive prior to installing aft most wearpad. Ensure holes are properly aligned.

A/R Sikaflex-291

Sikaflex expire date: 11/06

2-Install inserts & wearplates as per Dwg. D2750 Detail K & Q and IIN-D350-636 Page 4. Use a drop of Sikaflex in insert holes before installing wearpad/wearplate. AN3-6A bolts are installed AFT.


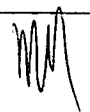

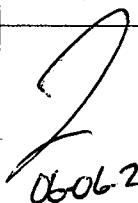
A/R Sikaflex-291

Sikaflex expire date: 11/06

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
060609	33.2	QCS Inspections ents. prior to installing wear-plates.	<i>[Signature]</i>	060613	1	<i>[Signature]</i>	<i>[Signature]</i> 060609

Part No: D350-636-012 PAR #: S/A Fault Category: Free - LG NCR: Yes No DQA: A Date: 060720  
 QA: N/C Closed: A Date: 060720

NCR: 25314		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
060622	33	Skid badly scratched at the Aft saddle location, from the ASSY table. A metal chip was on the support, and the tube was rotated in the support, causing a few big scratches.	 06/06/22	Remove hardware & wear plates. Re-powder coat white as per RS1004, QS1005.	DL 06/06/22	 060622	 060622	 060622

NOTE: Date & initial all entries

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Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #: Machine Or Operation: Description :

3-Install D2745 Bushing as per Dwg. D2750 Detail M

4-Install A3235-020-935 Plug as per Dwg. D2750 Detail L

5-Install AN3-6A Bolt as per Dwg. D2750 Detail Q

*DL 06/06/13* **(210)** **(1)**

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*mt 06/07/13* **(1)**

35.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

36.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

1 D2741

Blade

625938 ✓

37.0

AN960JD816

1/2" washer, Alum



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN960JD816

Washer

06956 ✓

38.0

MS21083N8

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 MS21083N8

Nut

0100993 ✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.06.09 ↓	33.6	QCS - Inspect for foreign objects in tube.  DC 06/06/13 ①					06.06.09	
✓	33.7	ASSEMBLE D2742-2 AS per Dwg. Sika Flex <sup>291</sup> B # <u>1101126</u> exp <u>11/09</u>  DC 06/06/14 ①					06.06.09	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 25314

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN816A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Kit Picking

Qty Part Number

Description

Batch

2 AN8-16A

Bolt

715760V

AL 06/07/19

①

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

See AL

AL 06/07/19

①

42.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06.07.20

Job Completion



AL 06.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN <i>DAH</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>DAH</i>	APPROVED <i>KE</i>	DRAWING NO. D2750	REV. C SHEET 1 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE MS24694-S293 TO AN8-16A	
C	98.11.18	ADD D2750-3/D2750-4 INCORPORATE D2738 AND D2740	
CI	<i>CP</i> 05.01.20	CHANGE QTY WEARSHOE HOLES, AS MANUFACTURED	

RELEASED  
98.12.16 DS

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D2750-041	SKIDTUBE ASSEMBLY, LH
	X			D2750-042	SKIDTUBE ASSEMBLY, RH
		X		D2750-043	SKIDTUBE ASSEMBLY, LH
			X	D2750-044	SKIDTUBE ASSEMBLY, RH
3	3	3	3	D2648-3	WEARPAD
2	2	2	2	D2648-5	WEARPAD
1	1	1	1	D2739	WEB
1	1	1	1	D2741	BLADE
1		1		D2742-1	BLADE FITTING, LH
	1		1	D2742-2	BLADE FITTING, RH
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
8	8			A3235-020-935	PLUG
<del>40</del>	<del>40</del>	<del>40</del>	<del>40</del>	AN3-5A	BOLT
8	8	8	8	AN3-6A	BOLT
4	4			AN3-32A	BOLT
4	4	4	4	AN6-44A	BOLT
2	2	2	2	AN8-16A	BOLT
1	1	1	1	AN8-35A	BOLT
3	3	3	3	MS21083N8	NUT
4	4			MS21042L3 OR MS21042-3	NUT
4	4	4	4	MS21042L6 OR MS21042-6	NUT
4	4	4	4	AN960JD10	WASHER
<del>44</del>	<del>44</del>	<del>44</del>	<del>44</del>	AN960JD10L	WASHER
4	4	4	4	AN960JD816	WASHER
<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	<del>44</del> 42	ALS4-1032-225 or AKS4-1032-225 or ALS7-1032-225 or AKS7-1032-225	INSERT

EFFECTIVE	DEOS
D20 4133 DS 48.01.19 DS	D20 4137 DS 48.10.21 DS

1.000 30.11.98  
SUBJECT TO  
WIT

25314



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2750	REV. C SHEET 2 OF 4
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS

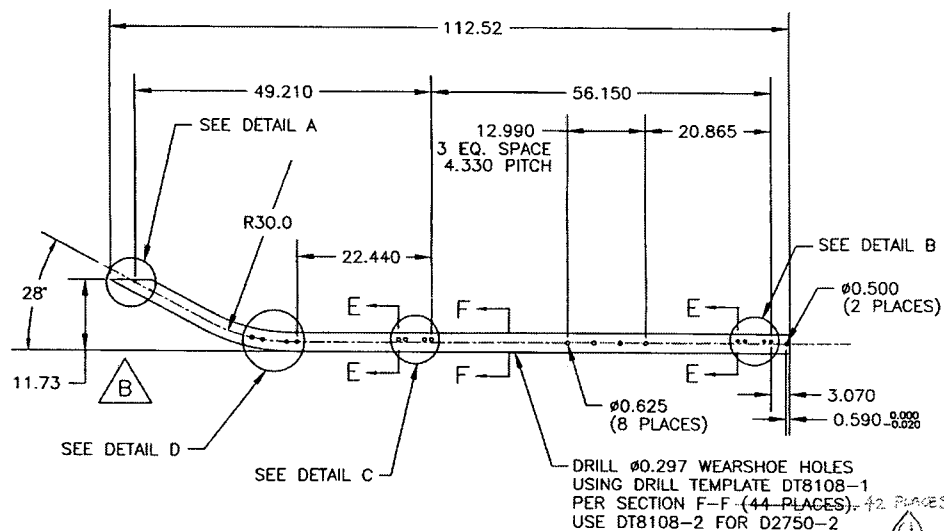
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
3. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
4. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E AND F-F.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
7. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2734 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
8. INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4.
9. D2742-1 (OR D2742-2) BLADE FITTING AND AN3-5A/AN3-6A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.

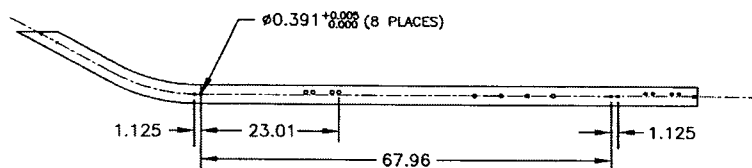
EFFECTIVE	DEOs
DEO 4133 98.01.19 DS	DEO 4157 99.10.21 DS

RELEASED  
98.12.16 DS

EXHIBIT TO  
MIL-STD

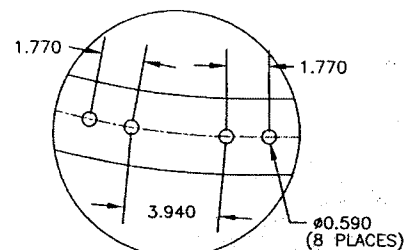
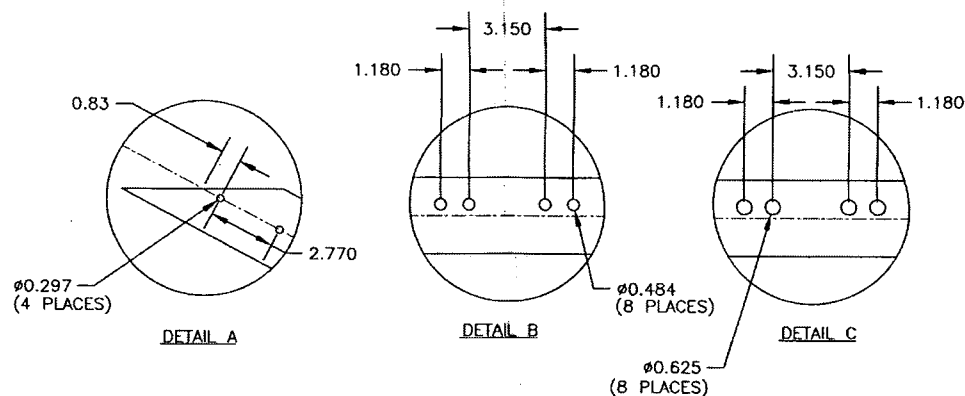


D2750-1 LH SKIDTUBE (SHOWN)  
D2750-2 RH SKIDTUBE (OPPOSITE)

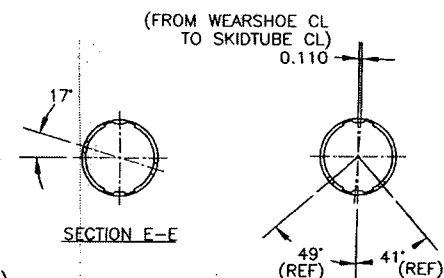


D2750-3 LH SKIDTUBE (SHOWN)  
D2750-4 RH SKIDTUBE (OPPOSITE)

D2750-3/-4 ARE THE SAME AS D2750-1/-2 EXCEPT THAT DETAIL D HOLES  
ARE REPLACED BY HOLE CONFIGURATION GIVEN ABOVE.



(ALL DIMENSIONS ARE  
STRAIGHT LINE DIMENSIONS)



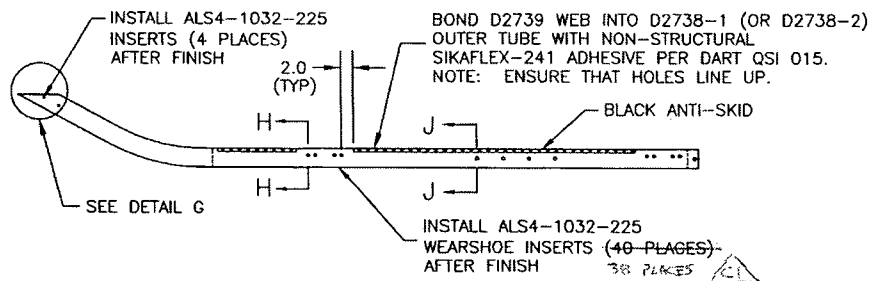
RELEASED  
98.12.16 DS

EFFECTIVE	DEOS
DES 9133 98.01.19 DS	DES 9137 99.02.21 DS

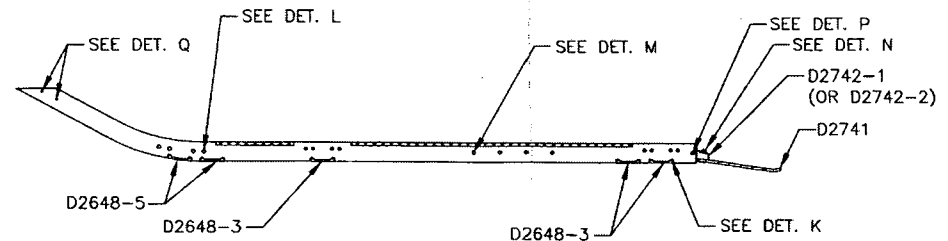
DESIGN 98	DRAWN BY CP	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 98	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18	TITLE 350 SKIDTUBE ASSEMBLY	REV. C SHEET 3 OF 4 SCALE 1:20

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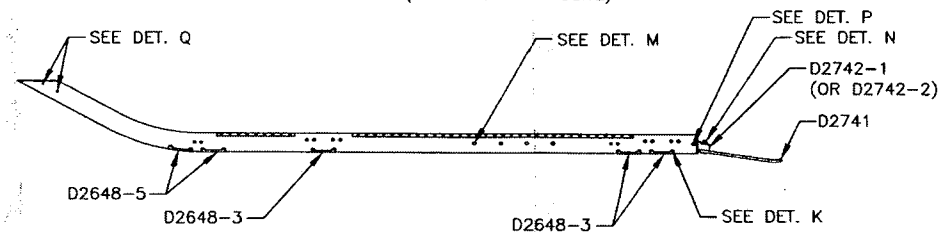
**D2750-1/-2/-3/-4 WELDING DETAIL**  
(FLOAT ATTACHMENT HOLES REMOVED)  
D2750-1/-3 SHOWN (D2750-2/-4 OPPOSITE)



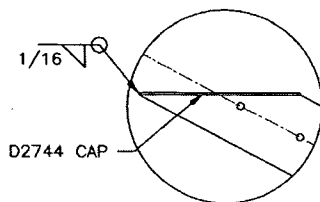
**D2750-041/-042 ASSEMBLY**  
D2750-041 SHOWN (D2750-042 OPPOSITE)



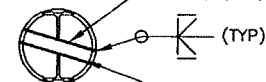
**D2750-043/-044 ASSEMBLY**  
D2750-043 SHOWN (D2750-044 OPPOSITE)



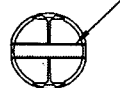
**DETAIL G**



**SECTION H-H**



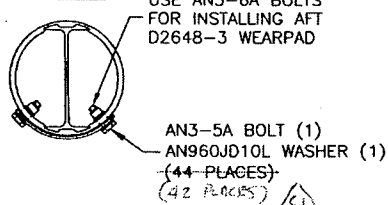
**SECTION J-J**



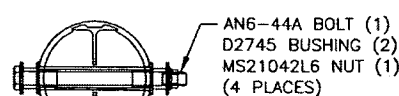
**WELDING INSTRUCTIONS**

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2743 SPACER
3. WELD INTO PLACE
4. GRIND FLUSH
5. DRILL OUT SPACER TO Ø0.484
6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

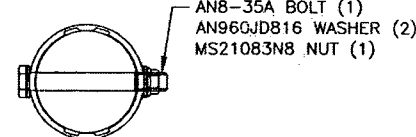
**DETAIL K**



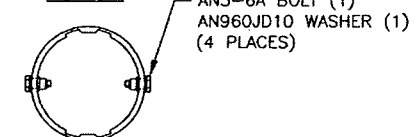
**DETAIL M**



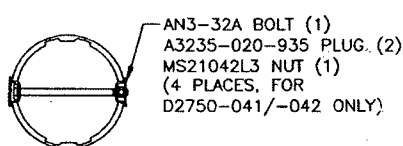
**DETAIL P**



**DETAIL Q**



**DETAIL L**



**DETAIL N**



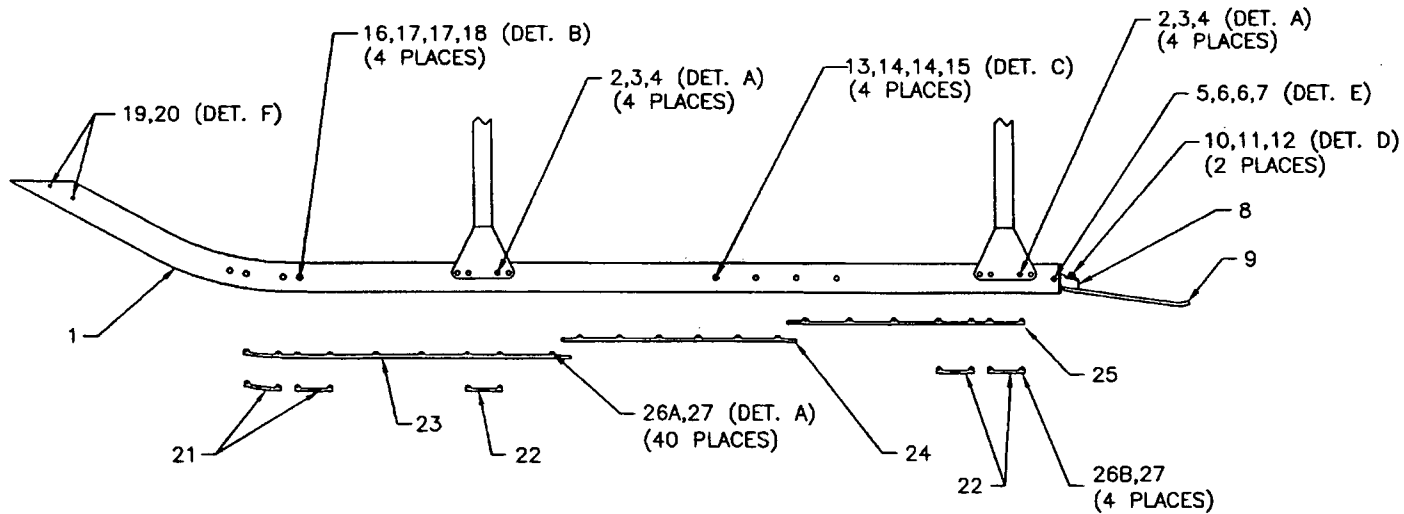
**RELEASED**  
98.12.16 DS

EFFECTIVE	DEOs
DES 9133 98.01.19 DS	DES 9157 98.10.21 DS

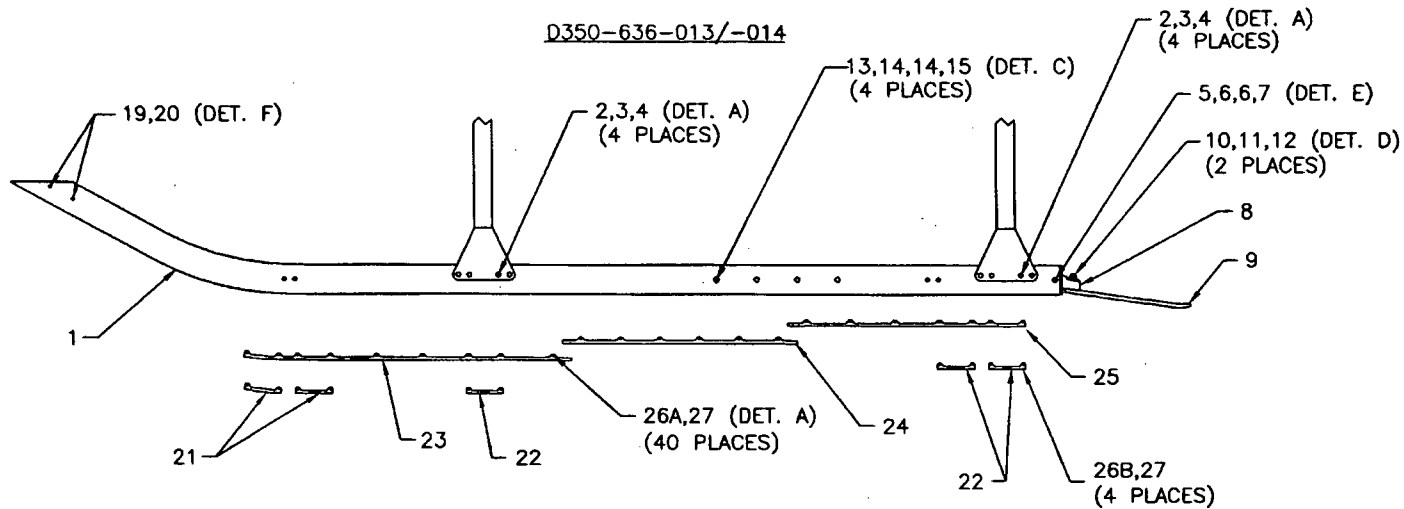
DESIGN 98	DRAWN BY 98	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED 98	APPROVED KE	DRAWING NO. D2750
DATE 98.11.18		TITLE 350 SKIDTUBE ASSEMBLY
		REV. C SHEET 4 OF 4 SCALE 1:20

NO. 25314

D350-636-011/-012



D350-636-013/-014



Revision: **C**  
Date: 98.11.19

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